

16

<b>DART AEROSPACE LTD.</b>	<b>Work Order :</b>	<b>20559</b>
<b>Description: 206 Saddle, Outboard, Left Side</b>	<b>Part Number:</b>	<b>D2665-1</b>
<b>Drawing: D2665 Rev B</b>	<b>Qty:</b>	<b>12</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>HA</i>	04.03.24	12
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (D6101-003) RF 02/09/16 Batch No: <b>B21321</b>	<i>EP</i>	04/08/26	12
3	HAAS	Program batch number.	<i>EP</i>	04/08/26	17
4	QC	Inspect part number and batch number are programmed correctly.	<i>ML</i>	04/08/26	12
5	HAAS	Fixturing W/O No. <i>N/A</i> Fixturing Inspection last completed on <i>04/08/26</i>	<i>EP</i>	04/08/26	12
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	04/08/30	12
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	04/08/30	12
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>EP</i>	04/08/30	12
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>EP</i>	04/08/30	12
12	METAL	Deburr	<i>EP</i>	04/08/30	12
13	HAAS	Inspect Level 1	<i>EP</i>	04/08/30	12
14	QC	Inspect Level 8	<i>HA</i>	04.09.01	12
15	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>EP</i>	04/09/02	12
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>EP</i>	04.09.09	12
17	QC	Inspect Level 3	<i>ML</i>	04.09.09	12
18	STORES	Pack in foam, identify and stock.	<i>CL</i>	04/09/14	12
19	EXPEDITING	Close Work Order Job Cost / Part <b>80.77</b> <i>545 04/09/15 (12)</i>	<i>HA</i>	04.09.15	12

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	<i>L.</i>

RELEASED

DEC 18 2000

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order: 20559
Description: 206 SADDLE, OutBOARD, Left Side		Part Number: D2665-1
Inspection Dwg: D2665 Rev: B		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
L	Ø 0.312	$\pm 0.005$ <del><math>\pm 0.000</math></del>	0.312	✓		DT 8686	
P	0.500	$\pm 0.010$	0.501 / 0.501	✓		vern	
E	1.250	$\pm 0.005$	1.251	✓		vern	
	2.500	$\pm 0.005$	2.502	✓		vern	
F	1.250	$\pm 0.005$	1.252	✓		vern	
G	6.000	$\pm 0.010$	6.002	✓		vern	
	0.375	$\pm 0.010$	0.377	✓		vern	
	R 0.250	$\pm 0.010$	0.250	✓		R. G	
	R 0.575	$\pm 0.010$	0.575	✓		R. G	
	0.050 x 45°	$\pm 0.010$ <del><math>\pm 0.005</math></del>	0.050 x 45°	✓		vern / Bevel Protractor	
Q	3.614	$\pm 0.005$	3.612	✓		vern	
	1.362	$\pm 0.005$	1.362	✓		vern	
T	0.800 / 0.180		0.148	✓		vern	
	0.797	$\pm 0.010$	0.794	✓		vern	
	R 0.50	$\pm 0.030$	0.50	✓		R. G	
U	Ø 0.313	$\pm 0.005$ <del><math>\pm 0.000</math></del>	0.313	✓		DT 8686	
	0.922	$\pm 0.010$	0.926	✓		vern	
14	Ø 0.257	$\pm 0.005$ <del><math>\pm 0.000</math></del>	0.257	✓		DT 8683	
S	2.500	$\pm 0.005$	2.499			vern	
I	1.679	$\pm 0.005$	1.679			vern	
O	0.550	$\pm 0.010$	0.548	✓		vern	

Measured by: EP	Audited by: gml	Prototype Approval: N/A
Date: 04/08/20	Date: 04/08/20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 20558
Description: 206 SADDLE, OUTBOARD, LEFT SIDE		Part Number: D2665-1
Inspection Dwg: D2665 Rev: B		Page 2 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R	2.470 / 2.510		2.508	✓		vern	
W	0.100 / 0.140		0.222	✓		m.c	
V	1.135	+0.010	1.130	✓		Depth mic.	
D	0.220	+0.010	0.222	✓		mic	
S	0.250	+0.010	0.260	✓		vern	
B	0.100 / 0.140		0.131	✓		vern	
	0.625	+0.010	0.630	✓		vern	
A	0.100 / 0.140		0.133	✓		vern	
R	0.50	+0.030	0.50	✓		R.G	
C	0.100 / 0.140		0.125	✓		vern	
	1.000	+0.010	1.004	✓		vern	
	0.510 / 0.515		0.512	✓		vern	
	0.235 / 0.240		0.235	✓		vern	

Measured by: Er	Audited by: JML	Prototype Approval: N/A
Date: 04/08/26	Date: 04/08/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20559
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2665-1
<b>Inspection Dwg:</b> D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	FAIL SHEET	2	3	4	By	Date
A	0.100	0.140			0.130	0.130	0.130		
B	0.100	0.140			0.133	0.131	0.132		
C	0.100	0.140			0.128	0.128	0.128		
D	0.210	0.230		0.226	0.226	0.222	0.223		
E	1.245	1.255			1.250	1.250	1.250		
F	1.245	1.255			1.250	1.245	1.250		
G	5.990	6.010			6.004	6.003	6.003		
H	0.510	0.515			0.512	0.512	0.512		
I	1.674	1.684		1.679	1.679	1.680	1.679		
J	2.495	2.505		2.498	2.500	2.500	2.499		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240			0.235	0.235	0.235		
N	0.100	0.140		0.126	0.126	0.122	0.123		
O	0.540	0.560			0.547	0.547	0.546		
P	0.490	0.510			0.502	0.500	0.496		
Q	3.609	3.619		3.613	3.612	3.613	3.612		
R	2.470	2.510			2.504	2.503	2.506		
S	0.240	0.270			0.256	0.257	0.256		
T	0.100	0.180			0.143	0.143	0.143		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.130	1.130	1.133	1.133		
W	1.565	1.585			1.570	1.571	1.575		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	04/08/130

Audited by:	me
Date:	04/08/130

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>20559</b>
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	<b>D2665-1</b>
<b>Inspection Dwg:</b> D2665 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.129	0.128	0.129	0.131		
B	0.100	0.140		0.131	0.132	0.132	0.130		
C	0.100	0.140		0.126	0.126	0.129	0.127		
D	0.210	0.230		0.226	0.223	0.220	0.226		
E	1.245	1.255		1.252	1.252	1.245	1.251		
F	1.245	1.255		1.252	1.250	1.249	1.250		
G	5.990	6.010		6.003	6.003	6.004	6.004		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.680	1.681	1.680		
J	2.495	2.505		2.498	2.499	2.502	2.498		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.236	0.235	0.236		
N	0.100	0.140		0.127	0.123	0.123	0.125		
O	0.540	0.560		0.544	0.543	0.545	0.543		
P	0.490	0.510		0.499	0.499	0.498	0.501		
Q	3.609	3.619		3.612	3.612	3.613	3.612		
R	2.470	2.510		2.503	2.500	2.505	2.505		
S	0.240	0.270		0.255	0.256	0.256	0.256		
T	0.100	0.180		0.143	0.139	0.134	0.135		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.136	1.133	1.134	1.134		
W	1.565	1.585		1.570	1.575	1.575	1.578		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Ep
Date:	04/08/30

Audited by:	gm
Date:	04/08/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	20559
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2665-1
<b>Inspection Dwg:</b> D2665 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.131	0.133	0.129	0.127		
B	0.100	0.140		0.130	0.131	0.131	0.131		
C	0.100	0.140		0.122	0.129	0.129	0.126		
D	0.210	0.230		0.222	0.226	0.226	0.224		
E	1.245	1.255		1.252	1.249	1.251	1.251		
F	1.245	1.255		1.251	1.250	1.251	1.250		
G	5.990	6.010		6.004	6.005	6.006	6.006		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.680	1.680	1.680	1.679		
J	2.495	2.505		2.499	2.499	2.499	2.498		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.236	0.236	0.235	0.236		
N	0.100	0.140		0.123	0.125	0.126	0.127		
O	0.540	0.560		0.543	0.544	0.543	0.547		
P	0.490	0.510		0.495	0.502	0.500	0.497		
Q	3.609	3.619		3.611	3.611	3.612	3.611		
R	2.470	2.510		2.505	2.505	2.506	2.506		
S	0.240	0.270		0.257	0.256	0.256	0.257		
T	0.100	0.180		0.143	0.140	0.140	0.140		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.136	1.135	1.135	1.135		
W	1.565	1.585		1.578	1.576	1.576	1.574		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Ep
Date:	04/08/30

Audited by:	gmk
Date:	04/08/30

Rev.	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Mar 23, 2004  
10:58 am

Work Order No : 0020559  
Project Name : D2665-1  
Project For : WK416  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2665-1  
Description : Saddle, LH Fwd Aft Out  
Manufactured : Yes  
Amount Req'd : 12  
Amount Done : 0  
Start Date : 03-23-04  
Est Finish Date : 04-15-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00